

Work Order ID 56423

February 23, 2010 12:40:50 PM



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Item ID: D2858-1

Revision ID:

Item Name: Hinge Bracket

Start Date: 25/02/2010 Start Qty: 20.00

Required Date: 05/03/2010 Req'd Qty: 20.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2858	Rev B

100 BAND SAW 0.00
 BANDSAW 0.00
 Bandsaw Memo
 Jeaspa Bandsaw Cut blanks 6.02" □Note: 1 Blank Makes 3 Parts
 21 0 10/02/24

110 HAAS CNC VERTICAL MACHINING #1 0.00
 HAAS 1 0.00
 HAAS CNC vertical machine #1 Memo
 1-Machine per folio D2858-1 □2-Deburr as per Dwg D2858000
 21 0 10/02/24

120 QC2- Inspect parts off machine FAI/FAIB 0.00
 QC 0.00
 Quality Control Memo
 21 0 10/02/24

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Item ID: D2858-1	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Hinge Bracket					
Start Date: 25/02/2010	Start Qty: 20.00		Cust Item ID:		
Required Date: 05/03/2010	Req'd Qty: 20.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	amk 10/02/24			21	10		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	⇒ m-h 10/02/25					21X	
150 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M113120 Memo START TIME: 10:30AM FINISH TIME: 11:00AM	0.00 0.00	⇒ JH 10/02/25					X21	

OVEN TEMPERATURE: 320°F

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Item ID: D2858-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Bracket

Start Date: 25/02/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 05/03/2010 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

8/10/02/25

100%

(21)



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location:

27

0.00

0.00



Packaging

Memo

Packaging

P 10/3/0 1 (21)

180

QC21- Final Inspection - Work Order Release

0.00

0.00



QC

Memo

Quality Control

10/03/03

C 203/01/10

Picklist Print

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Work Order ID: 56423



Parent Item: D2858-1



Parent Item Name: Hinge Bracket

Start Date: 25/02/2010

Required Date: 05/03/2010

Comments: IPP ☐ C ☐ 00.06.22 ☐ Removed P/O for powder coat ☐ EC ☐

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.500X01.25 0		Purchased	No			100	f	56.5410	3.5432			



6061-T6 Bar 1.50 x 1.25

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

56.5409921

107461

11.84

110936

44.7009921

35116 ^{ft}

B.A 10/02/24

DART AEROSPACE LTD		Work Order:	56428
Description: Hinge Bracket		Part Number:	D2858-1
Inspection Dwg: D2858 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

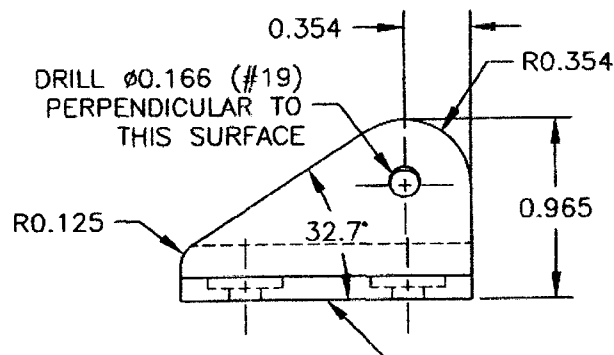
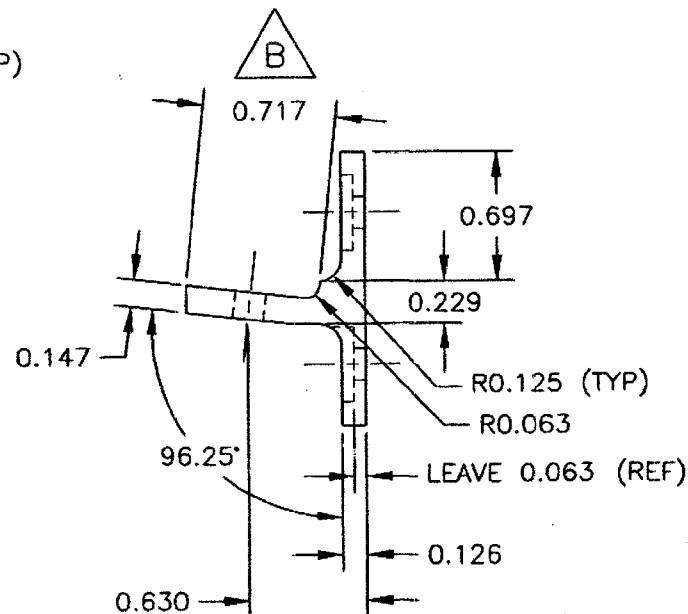
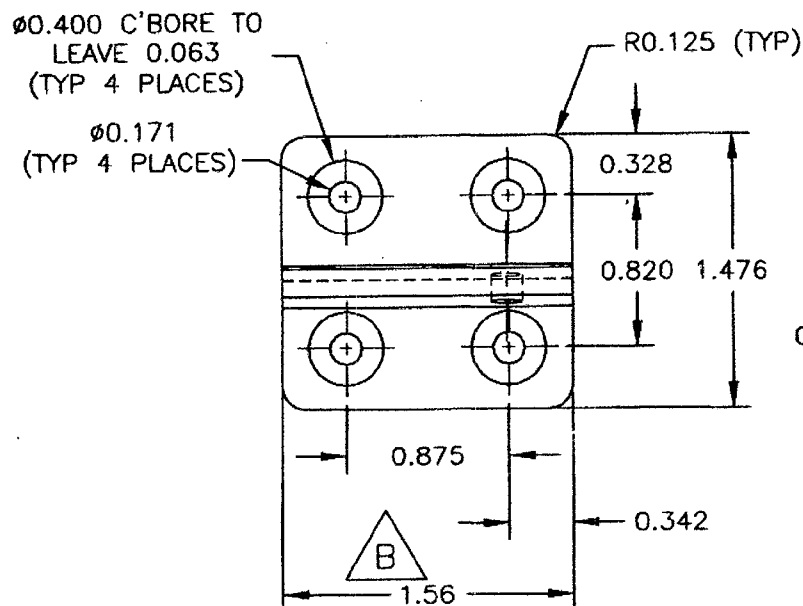
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.171	+0.005/-0.001	Ø0.174	✓			
Ø0.400	+0.006/-0.001	Ø0.399	✓			
R0.125	+/-0.010	R0.125	✓			
0.328	+/-0.010	0.329	✓			
0.820	+/-0.005	0.820	✓			
1.476	+/-0.010	1.478	✓			
0.342	+/-0.010	0.343	✓			
0.875	+/-0.005	0.875	✓			
1.56	+/-0.030	1.562	✓			
0.147	+/-0.010	0.144	✓			
0.717	+/-0.010	0.716	✓			
0.697	+/-0.010	0.695	✓			
0.229	+/-0.010	0.230	✓			
R0.125	+/-0.010	R0.125	✓			
R0.063	+/-0.010	R0.063	✓			
0.063	+/-0.010	0.069	✓			
0.126	+/-0.010	0.128	✓			
0.630	+/-0.010	0.632	✓			
R0.354	+/-0.010	R0.354	✓			
0.965	+/-0.010	0.970	✓			
Ø0.166	+0.005/-0.001	Ø0.168	✓			
R0.125	+/-0.010	R0.125	✓			
32.7°	+/-0.5°	32.7°	✓			

Measured by:	B.A	Audited by:	[Signature]	Prototype Approval:	N/A
Date:	10/02/24	Date:	10/02/24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.30	New Issue	KJ/EC/DD	[Signature]

DART
RELEASED
 99.03.09 KE

DESIGN	DRAWN BY	DRAWING NO.	TITLE	DATE
VE	VE	D2858	HINGE BRACKET	99.02.28
CHECKED	APPROVED			
CP	JE			
A	98.12.14	NEW ISSUE		
B	99.02.28	0.717 WAS 0.667, 1.56 WAS 1.559		

 REV. B
 SHEET 1 OF 1
 SCALE 1:1


ENGRAVE P/N CENTERED ON BASE 0.003 DEEP (0.010 MAX)

D2858-1 SHOWN
 D2858-2 OPPOSITE

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)
 FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED